

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017566**Date Inspected:** 22-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

West Gate of Blast shop #1

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 009 as per the Welding repair report B-WR 16118 located on OBG Segment 12AE, SEG 3001A. Welder is identified as 054016. ZPMC Quality Control (QC) Inspector is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 4G (4F) – FCM -Repair.

Repair welding of weld joint # 045 as per the Welding repair report B-WR 16119 located on OBG Segment 12AE, SEG 3001X. Welder is identified as 215553. ZPMC Quality Control (QC) Inspector is identified as Wang Wei Ming. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – FCM -Repair.

Repair welding of weld joint # 046 as per the Welding repair report B-WR 16120 located on OBG Segment 12AE, SEG 3001X. Welder is identified as 215553. ZPMC Quality Control (QC) Inspector is identified as Wang Wei

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Ming. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 2G (2F) – FCM -Repair.

Bay #19

This QA Inspector observed the following work in progress

Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 011 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Xu Tao who was present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9501.

Blast shop # 1

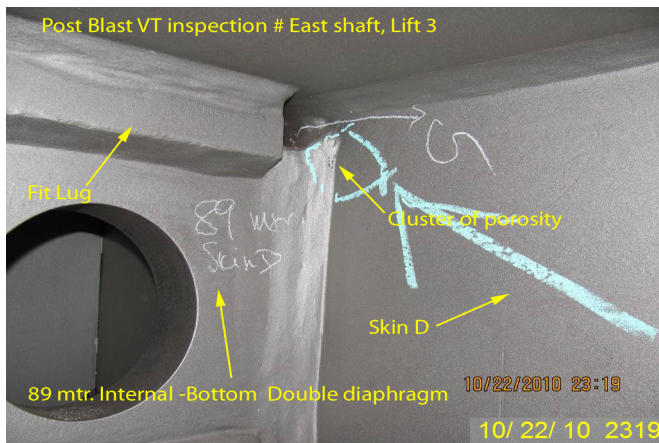
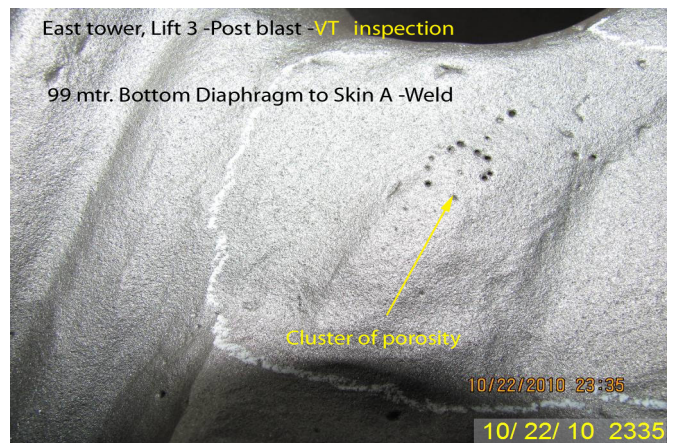
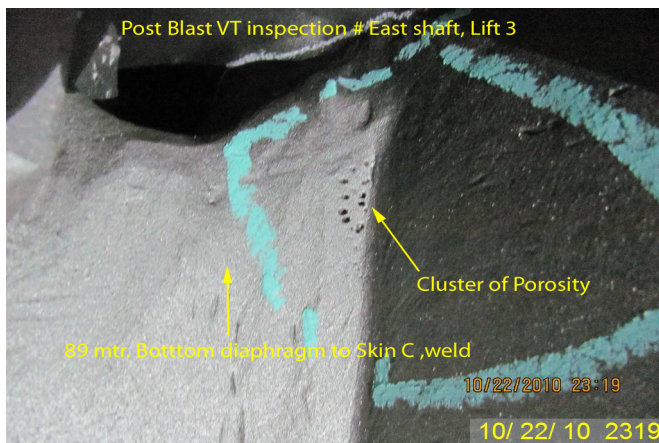
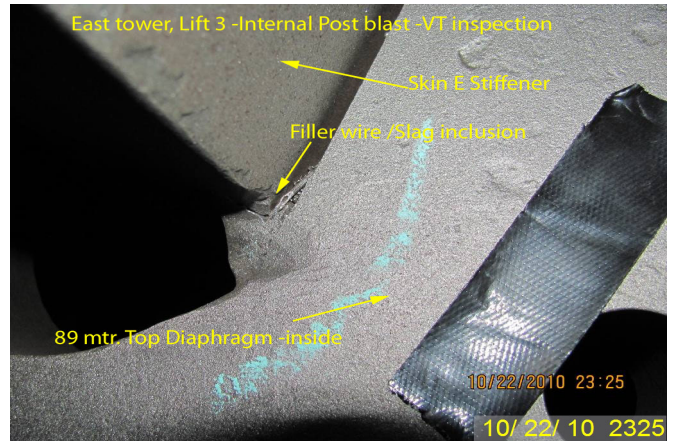
This QA inspector, Baskar Govindarajan, performed Post blast Visual inspection of Internal surfaces of East tower, Lift 3. All the areas marked which requires grinding, weld repair, Grinding & MT wherever applicable in all the Skins of Tower from 83 to 99 mtr. Bottom Diaphragm. This inspection was carried out along with QA Inspector Mr. Paul Dawson (B 254), Mr. George Goulet (B. 218) and Mr. Ken Riley. All the marked points shown to ZPMC inspector Mr. Sun Zhi Wang and ABF Inspector Mr. Wang Jiang Hua. All the weld repair areas (9 nos) marked in weld map in detail and the same was signed by ZPMC and ABF Inspector. Incident report rose for the same.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
